

Date: Monday, 4/23/2007 3:41:54 PM  
 User: Kim Johnston

## Process Sheet

(2)

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number	32022	Part Number	D29331
Estimate Number	10833	Drawing Number	D2933 REV C
P.O. Number	N/A	Project Number	N/A
This Issue	4/23/2007	Drawing Revision	C
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	5/15/2007
Previous Run	31490	Qty:	8
Written By		Um:	Each
Checked & Approved By			
Comment	Est: B 00.06.26 New-DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D6101001	7075-T7351 2X6X6.25 
		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: B25345 x 70cs <span style="margin-left: 100px;">B31386 x 1 PCS</span>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr <span style="margin-left: 100px;">J.R. 07/07/30</span> (8)
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
		
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <span style="margin-left: 100px;">J.R. 07/07/30</span> (8)
4.0	QC1	INSPECT ALL DIM TO DIM SHEET 
		
		Comment: INSPECT ALL DIM TO DIM SHEET <span style="margin-left: 100px;">J.R. 07/07/30</span> (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes        No        DQA:        Date: 09/18/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:41:54 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 32022

Part Number: D29331

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



JM/07-07-31

Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MJ

07-08-01

8

7.0 POWDER COATING POWDER COATING



M105068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BK

07-08-02

8

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MJ

07/08/02

8x

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

EP/07/08/02/08

8

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/03

Job Completion



JM/07-08-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 32022

Description: 206 Saddle, Inboard, Left side

Part Number: D2933-1

Inspection Dwg: D2933 Rev. C

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		1.21"	1.21"	1.21"	1.21"		
B	0.100	0.140		1.190"	1.21"	1.21"	1.19"		
C	0.100	0.140		1.17"	1.17"	1.15"	1.15"		
D	0.210	0.230		2.19"	2.20"	2.20"	2.21"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
H	0.510	0.515		5/12"	5/12"	5/12"	5/12"		
I	1.572	1.582		1.578"	1.578"	1.578"	1.578"		
J	2.495	2.505		2.501"	2.501"	2.501"	2.501"		
K	0.257	0.262		0.258"	0.258"	0.258"	0.258"		
L	0.312	0.317		0.314"	0.314"	0.314"	0.314"		
M	0.235	0.240		0.239"	0.239"	0.239"	0.239"		
N	0.100	0.140		1/8"	1/8"	1/8"	1/8"		
O	0.540	0.560		1.551"	1.550"	1.550"	1.551"		
P	0.490	0.510		1.503"	1.503"	1.503"	1.503"		
Q	3.715	3.725		3.721"	3.721"	3.721"	3.721"		
R	2.470	2.510		2.496"	2.496"	2.496"	2.496"		
S	0.240	0.270		1.248"	1.249"	1.250"	1.251"		
T	0.100	0.180		1.30"	1.30"	1.30"	1.30"		
U	1.625	1.635		1.630"	1.630"	1.630"	1.630"		
V	1.362	1.372		1.369"	1.369"	1.369"	1.369"		
W	0.316	0.321		0.319"	0.319"	0.319"	0.319"		
X	1.125	1.145		1.134"	1.134"	1.134"	1.134"		
Y	1.565	1.585	DT8695 A/B	1.580	1.581	1.580	1.580		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.E.Date: 07/07/20Audited by: J.E. 07-07-21

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM <u>J.E.</u>	<u>J.E.</u>

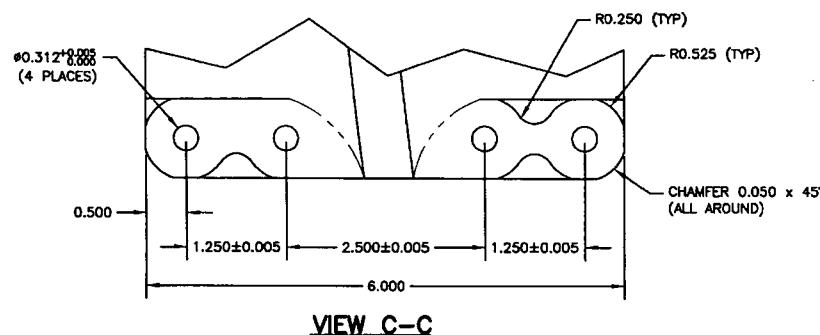
DART AEROSPACE LTD				Work Order:	32022
Description: 206 Saddle, Inboard, Left side				Part Number:	D2933-1
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.121	0.122	0.121	0.121		
B	0.100	0.140		0.121	0.121	0.120	0.121		
C	0.100	0.140		0.123	0.126	0.126	0.125		
D	0.210	0.230		0.218	0.219	0.219	0.219		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.249		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.580	1.578	1.578	1.577		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.118	0.118	0.118	0.118		
O	0.540	0.560		0.551	0.550	0.550	0.550		
P	0.490	0.510		0.502	0.503	0.503	0.503		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.492	2.492	2.495	2.494		
S	0.240	0.270		0.250	0.250	0.249	0.249		
T	0.100	0.180		0.136	0.136	0.135	0.138		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.367	1.367	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.132"	1.134"	1.133"	1.135		
Y	1.565	1.585	DT8695 A/B	1.579	1.580	1.578	1.580		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	JF	07/07/30	Audited by:	JL	07/07/31
Date:	07/07/31		Date:	07/07/31	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	

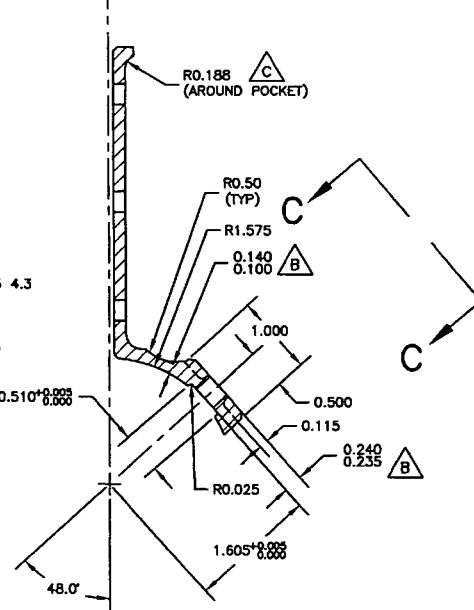


VIEW C-C

D2933-1 LH SADDLE (SHOWN)  
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (00-A-250/12)  
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

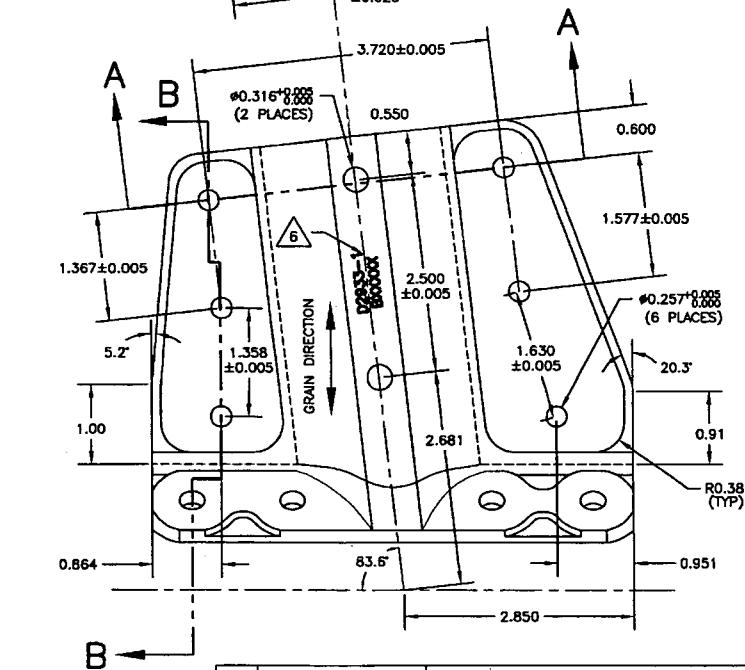
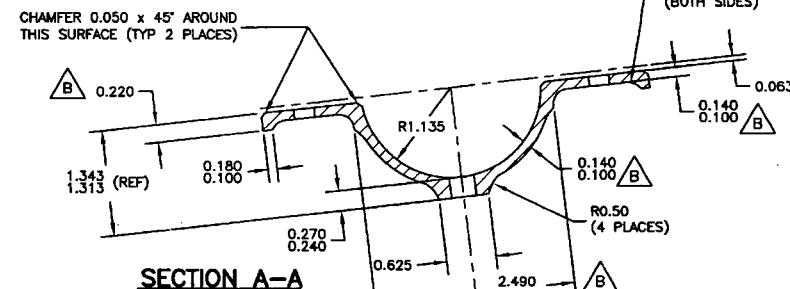


SECTION B-B

UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 32032

SHOP COPY  
 RETURN TO  
 ENGINEERING

FILED/AGED  
 07.02.12



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED <i>PH</i>	APPROVED <i>CB</i>	DRAWING NO. D2933 REV. C SHEET 1 OF 1
DATE 06.11.09	TITLE SADDLE INSIDE	SCALE 2:3

COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.  
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
 AND IS SUPPLIED ON THE EXPRESS CONDITION  
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
 OR COPIED OR COMMUNICATED TO ANY OTHER  
 PERSON WITHOUT WRITTEN PERMISSION FROM  
 DART AEROSPACE USA, INC.